

Date: Thursday, 31/07/2008 12:18:52 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP LH (FOLDING)
 Job Number : 40857
 Estimate Number : 12567
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 40268
 Written By :
 Checked & Approved By :
 Comment : Est. Rev:A New Issue 06-11-08 JLM
 est rev B ecn 1019, added d2807-041 EC verified by:DD

Part Number : D412630033
 Drawing Number : IIN D412-630
 Project Number : N/A
 Drawing Revision : L
 Material :
 Due Date : 25/08/2008 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Schedule for 08.13



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

02/07/02

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

Pick:

Qty Part Number Description
 1 D2012-107 Clevis

Batch

40274 x1 AS 08/11/13 (x1)
AS 08/08/16 (x5)
B33585 x4 40274 x1

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description
 2 D2803-041 Bracket Assembly LH

Batch

41053 x2 AS 08/11/13
35826 x4 AS 08/08/07

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description
 2 D2804-041 Bracket Assembly LH

Batch

41054 x2 AS 08/11/13
40278 AS 08/08/07

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2807041 Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch: 35751

35751 x2 AS 08/11/13 (x1)

AS 08/08/07 (x5)

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description
2 D2813 Washer

Batch

34020

34020 x2 AS 08/11/13 (x1)

AS 08/08/07 (x5)

7.0 D3562041 Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number Description
1 D3562-041 Step Weldment LH

Batch

B41245

B41648 CP 08/11/13 (x1)

CP 08/09/02 (x1)

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number Description
4 D3395-1 Bushing

Batch

33578

4041035 x4 AS 08/11/13 (x1)

AS 08/08/07 (x5)

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty Part Number Description
2 AN3C21A Bolt

Batch

101189

M101189 x2 AS 08/11/13 (x1)

AS 08/08/07 (x5)

Process Sheet

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN8C16

Bolt

106066

108969 x2 AS 08/11/13 (X)

AS 08/08/07 (X)

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

AN310C8

Nut

M106431 x2 AS 08/11/13 (X)

AS 08/08/07 (X)

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Cotter Pin

Pick:

Qty

Part Number

Description

Batch

2

MS24665-302

Cotter Pin (or AN380C3-4)

M106763

M106763 x2 AS 08/11/13 (X)

AS 08/08/07 (X)

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

6

NAS1515H3

Washer

M107101

M107101 x6 AS 08/11/13 (X)

AS 08/08/07 (X)

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H5L

Washer

M106541

M104956 x4 AS 08/11/13 (X)

AS 08/08/07 (X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

4

NAS1515H8

Washer

Batch

M106575 x 3 AS 08/11/13 (x1)
M109099 x 1

106575 x 11 M106575 x 9

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

4

MS21043-3

Nut

Batch

M108880 x 4 AS 08/11/13 (x1)

M108618 x 4 M108672 x 10

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty

Part Number

Description

2

MS24693-C280

Screw (or MS24694-C565)

Batch

M101390 x 2 AS 08/11/13 (x1)

M101390

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



08/09/02 (x2 LH)

08/11/13 (2)

Thursday, 31/07/2008 12:18:52 PM
Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: I

Job Number: 40857

Part Number: C

Job Number:



Seq. #: Machine Or Operation: Descri

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	

35630 x2 AS 08/11/14 (X1)
35638
35630 AS 08/09/02 (X2)

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	

36534 x2 AS 08/11/14 (X1)
636534 x6 AS 08/09/11 (X3)
B34019 AS 08/09/02 (X2)

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	

40900 x1 AS 08/11/14 (X1)
P41029 x3 AS 08/09/11 (X3)
41029 AS 08/09/02 (X2)

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	

34025 x2 AS 08/11/14 (X1)
34025 x6 AS 08/09/11 (X3)
34025 AS 08/09/02 (X2)

25.0 AN4G6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch

M107242 x1 AS 08/11/14 (X1)
M107242 x3 AS 08/09/11 (X3)
M107242 AS 08/09/02 (X2)

These kits
Pick kits
all + 12+1 op.
in comp.

Cool Beans!

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C10A

Description

Bolt

Batch

M101189 x1 AS 08/11/14 (X)

M101189 x3 AS 08/09/11 (X3)

M101189 AS 08/09/02 (X2)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4C15A

Description

Bolt

Batch

M107082 x2 AS 08/11/14 (X)

M107082 x6 AS (X3)

M107082 AS 08/09/02 (X2)

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

1 AN44-C7A

Description

Eyebolt

Batch

M100446 x1 AS 08/11/14 (X)

M100446 x3 AS (X3)

M100446 AS 08/09/02 (X2)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN5C15A

Description

Bolt

Batch

M105125 x2 AS 08/11/14 (X)

M105125 x6 AS (X3)

M105125 AS 08/09/02 (X2)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H4

Description

Washer

Batch

M108880 x1 AS 08/11/14 (X)

M108880 x7 AS (X3)

M108880 x2 AS 08/09/11 (X3)

All same batch was taken

M108880 AS 08/09/02 (X2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS1515H5 Washer

Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	

Batch

M108334 x7 SS 08/11/14 (x1)
 M108334 x21 SS (x3)
 M108334 SS 08/09/02 (x2)

32.0 MS210434 Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	

Batch

M109165 x4 SS 08/11/14 (x1)
 M108672 x12 SS (x3)
 M108672 SS 08/09/02 (x2)

33.0 MS210435 Nut

Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	

Batch

M109535 x3 SS 08/11/14 (x1)
 M108583 x9 SS (x3)
 M108583 SS 08/09/02 (x2)

34.0 QC4

INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

Kit (x3)
 08/11/14 (x1)
 08/09/02 (x2)
 08/09/02 (x2)
 08/11/14 (x1)
 08/09/02 (x2)
 08/09/02 (x2)
 08/09/02 (x2)

36.0

QC21

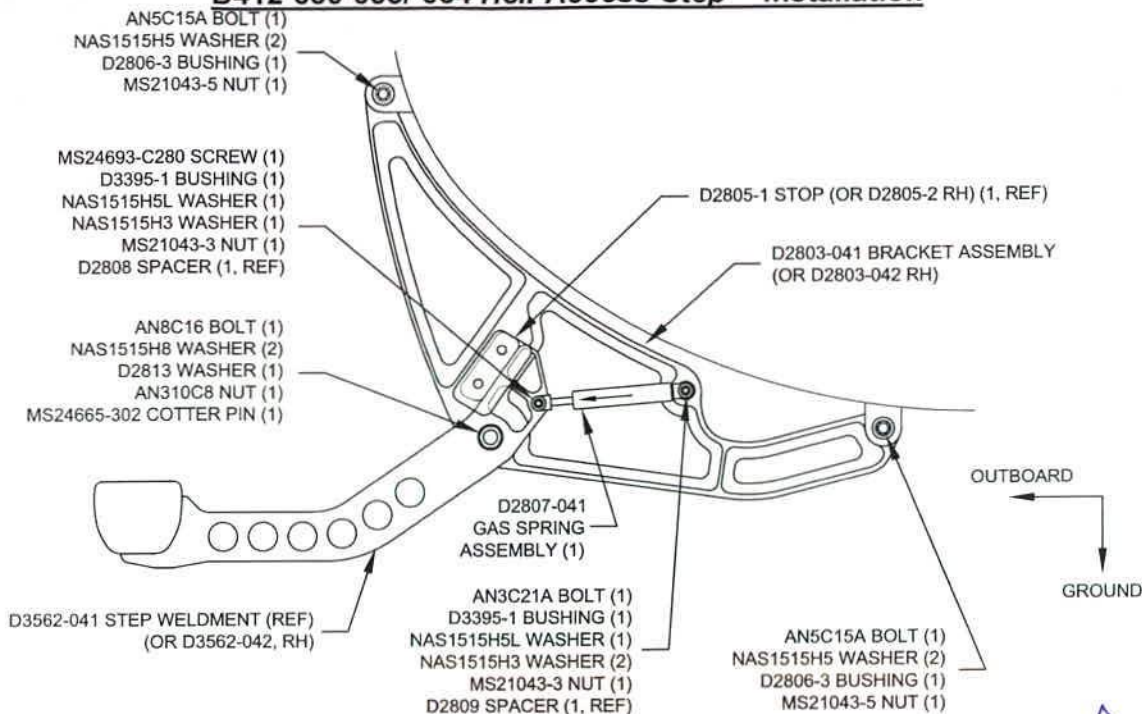
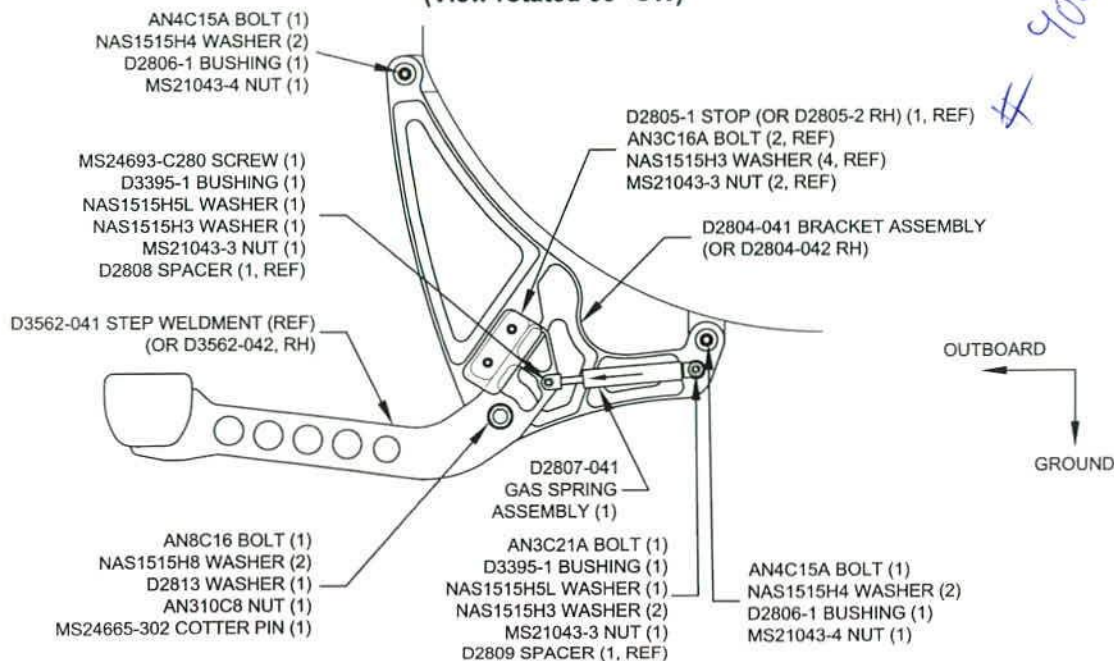
FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/09/02
 MF 08-11-14

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: L
Date: 07.09.30